

# Work Order ID 50128

July 8, 2009 11:50:01 AM



Item ID: D2221  
Revision ID: H  
Item Name: 350 Basket Base

Accept



Setup Start



Stop



Start Date: 7/09/09 Start Qty: 1.00  
Required Date: 7/24/09 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2221	Rev H
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100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221-12-  
remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per  
dwg D2221-13- tack weld mesh on basket as per dwg D2221-14 A/R ER316  
S.S. Rod Batch: *4109213*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

*PD 09.07.13*  
*SY 09/07/13*

*Cpl 09.07.14*

*=7 S 09/07/14*

*(51) 6*

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Item ID: D2221

Accept

Revision ID: H

Item Name: 350 Basket Base

Start Date: 7/09/09 Start Qty: 1.00

Required Date: 7/24/09 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

0.00

PRESSURE WASH 09-07-14 X JV  
1- Plug holes prior to TIME: 7:30am 2- 1ST COAT: START  
8:00am FINISH TIME: 4:00pm  
\*\*\*\*\* 2nd coat if necessary \*\*\*\*\* 8:30am 2ND COAT: START

M112148 09-07-15 X1 JV

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

09-07-16

150

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/07/21 J

h 09.07.17

# Picklist Print

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Page 1

Work Order ID: 50128

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Comments:

Start Date: 7/09/09

Required Date: 7/24/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2221-1RevH

Manufactured

No

100

Each

14.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

48101

1

48318

5

48427

8

1x

SY 09/07/09

D2221-5RevH

Manufactured

No

100

Each

4.0000

2.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

48390

4

2x

SY 09/07/09

D2221-7RevH

Manufactured

No

100

Each

6.0000

1.0000



Rib

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

48201

2

48450

4

1x

SY 09/07/09

# Picklist Print

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Page 2

Work Order ID: 50128

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	15.0000	2.0000			
												
Basket Hinge												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 15

47263 3

48443 12

D2235-1RevB1 Manufactured No 100 Each 7.0000 2.0000



Basket Rib



2x SJ 09/07/09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7

48665 7

D2581RevA1 Manufactured No 100 Each 35.0000 2.0000



Mounting Bracket



2x SJ 09/07/09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 35

46086 2

48428 33

2x SJ 09/07/09

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Shop Packet Print

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# Picklist Print

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Work Order ID: 50128

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-1RevA		Manufactured	No			100	Each	22.0000	2.0000			
												
Shim												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 22

46767 1

47074 9

50023 12

D3825-041RevA Manufactured No

100 Each 8.0000 2.0000



Rib Assembly (Basket End)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 8

48430 2

48668 6

D3826-041RevB Manufactured No

100 Each 6.0000 2.0000



Rib / Gusset Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 6

48644 6

2x *dy* 09/07/09

2x *dy* 09/07/09

2x *dy* 09/07/09

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Shop Packet Print

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# Picklist Print

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Work Order ID: 50128



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 7/09/09

Required Date: 7/24/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	7.0000	1.0000			



Rib Assembly (Inboard)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7

48100 1

48454 6

D3832-1RevA

Manufactured

No

100

Each

2.0000

1.0000



Mesh (Base)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 48645 > 1 2

46306 1

46774 1

D3833-1RevA

Manufactured

No

100

Each

7.0000

2.0000



Mesh (Base End Face)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7

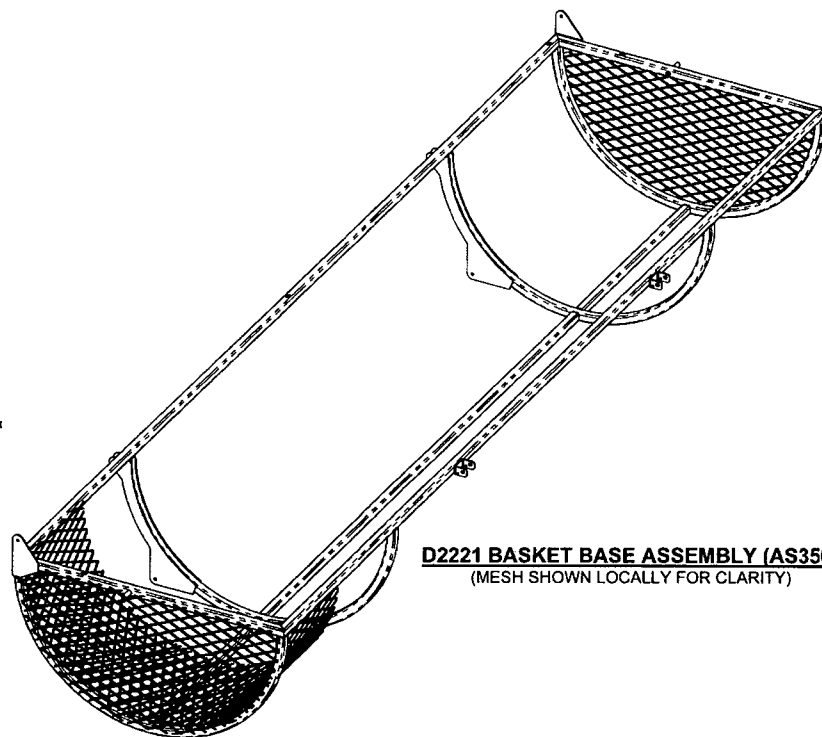
46665 1

48646 6

Lx 09/07/09

PD 09.07.13

2 PD 09.07.13



**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING

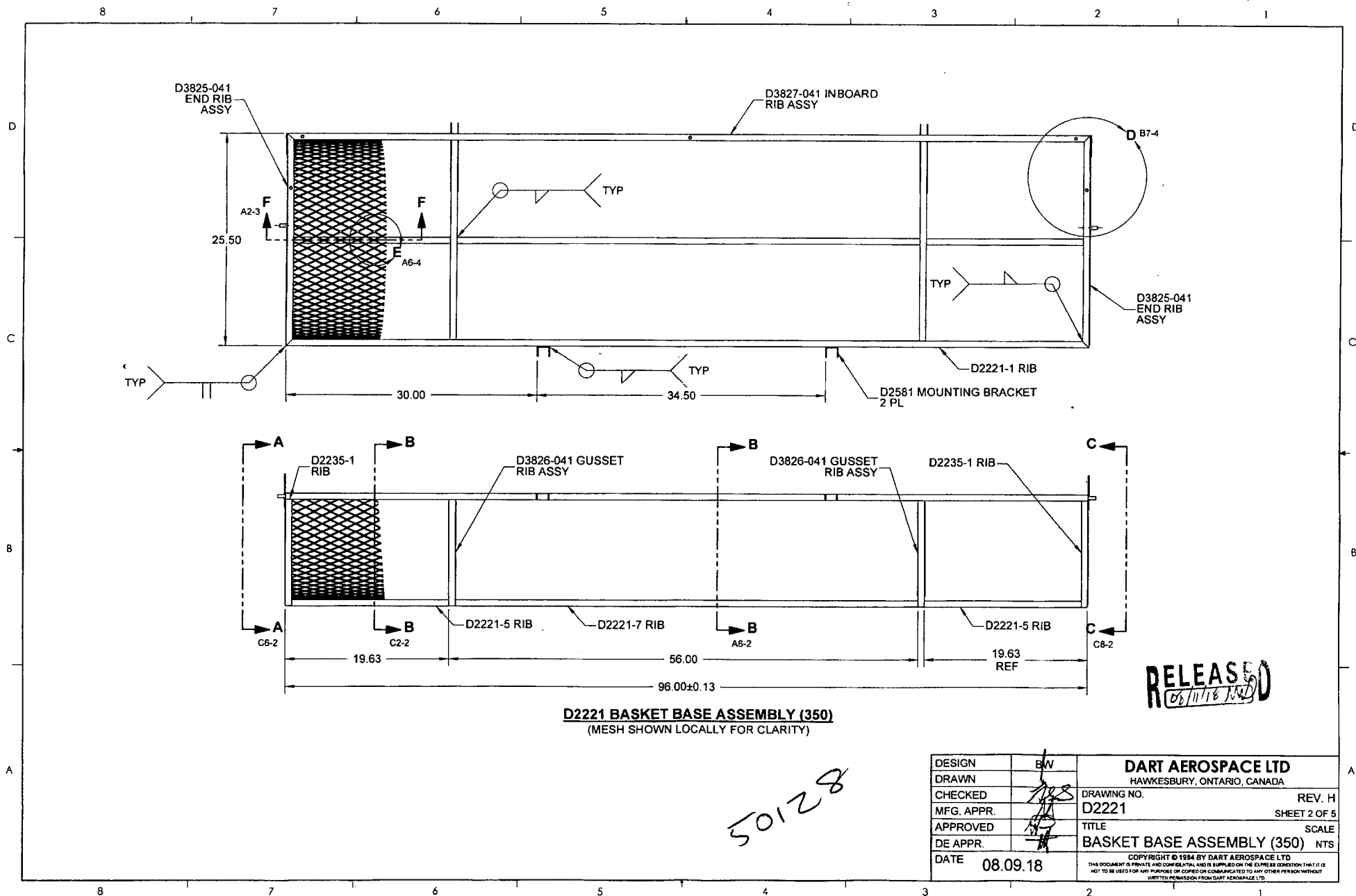


ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

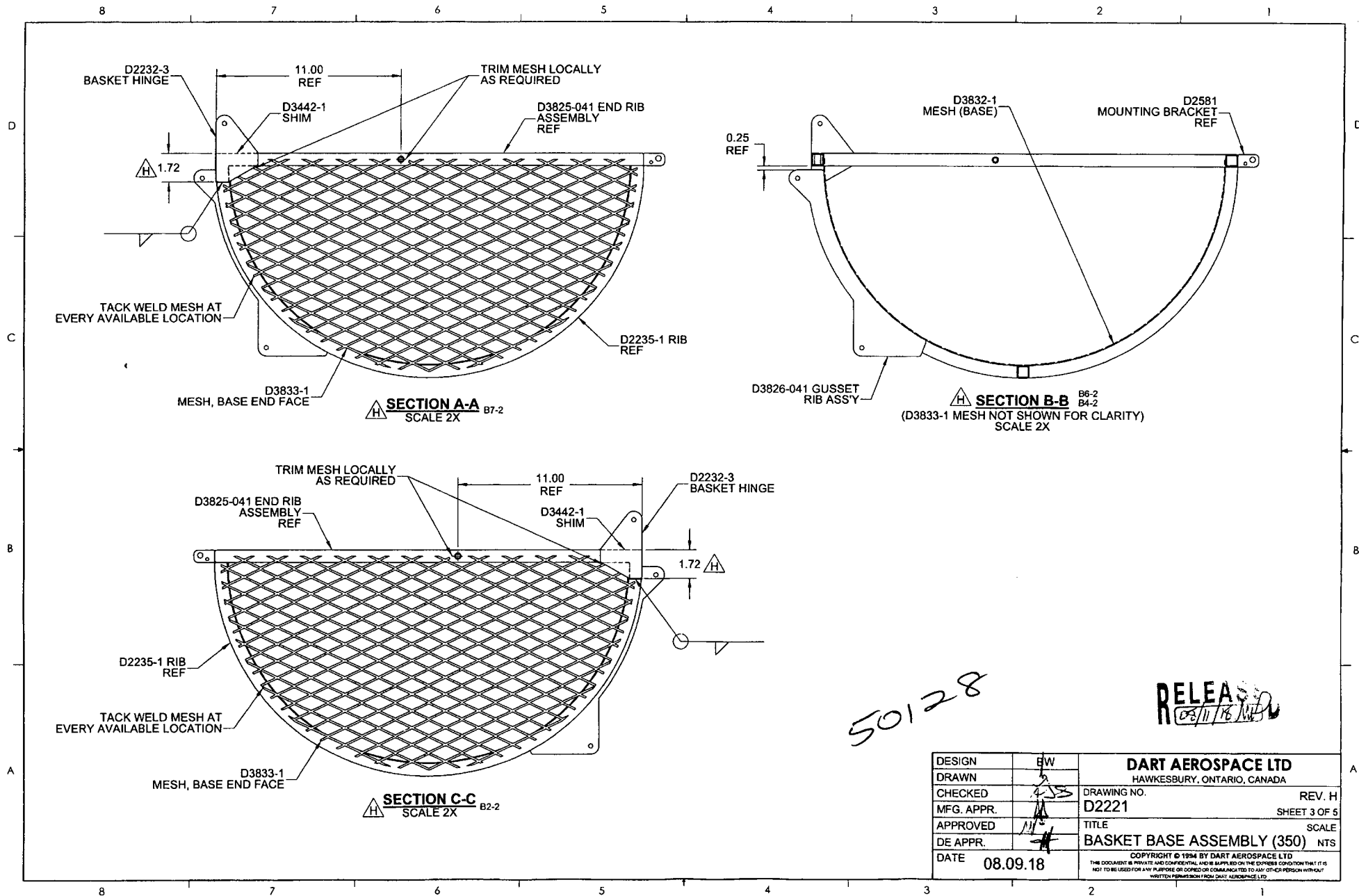
*Wb*  
*5/2/20*

**REVISED**  
*08/11/18*

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	







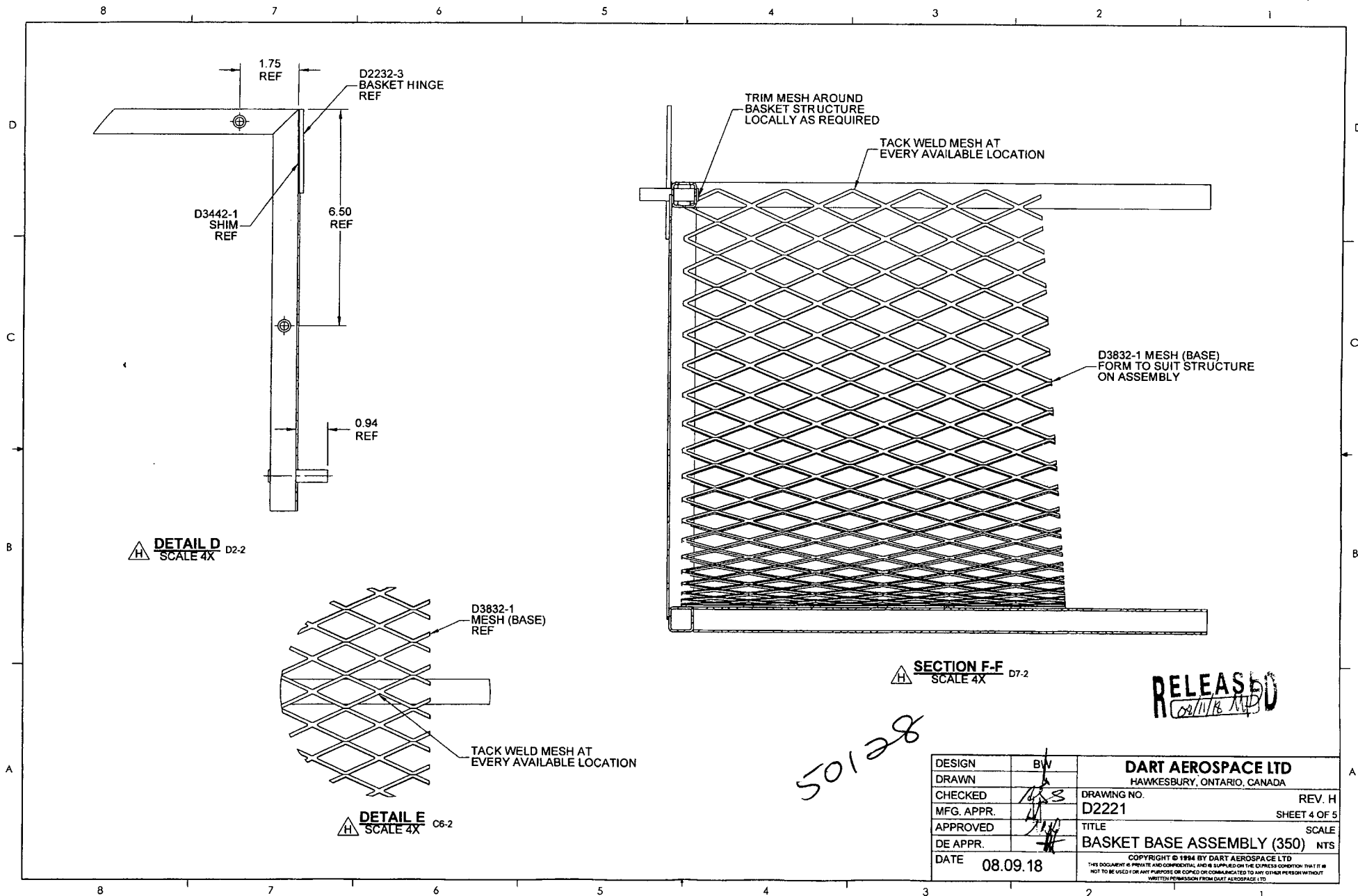




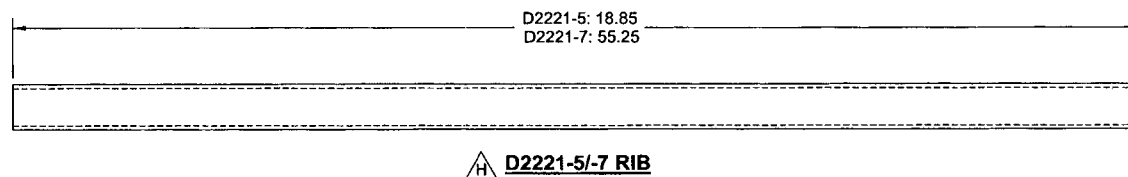
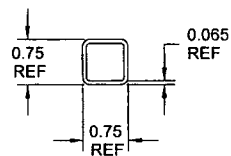
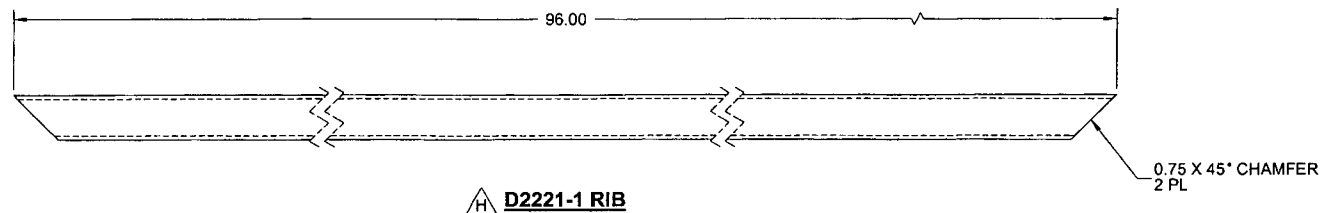
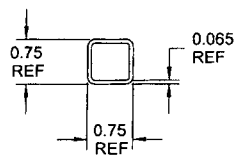
50128

RELEASE  
08/11/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET BASE ASSEMBLY (350) NTS</b>	
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET BASE ASSEMBLY (350) NTS</b>	
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50128

RELEASED  
08/11/15

# NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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